

slp 24/02

# Work Order ID 56409

February 23, 2010 10:14:10 AM



Item ID: D4050-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Strut

Start Date: 2/23/10 Start Qty: 1.00



Cust Item ID:

Required Date: 2/23/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: *W*

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4050

B

100

0.00



NC BRAKE

Brake NC

Memo

0.00

Brake NC

Punch per Dwg. D4050 and Spec Control Dwg D2638

SO 10/02/24

1 8

110

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Deburr

GP 10/02/24 (1)

120

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

SO 10/02/24

(40)

# Work Order ID 56409

February 23, 2010 10:14:10 AM



Page 2

Item ID: D4050-1

Accept



Setup Start



Revision ID:

Item Name: Strut

Stop



Start Date: 2/23/10 Start Qty: 1.00



Cust Item ID:

Required Date: 2/23/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00

M113170

Memo

0.00

= M 10/02/

(X1)

φ

START TIME: 10:45am  
OVEN TEMPERATURE: 400°F  
FINISH TIME: 11:10am

140



QC

Quality Control

QC3- Inspect Part Finish

0.00

BR 10-02-24

①

φ

Memo

0.00

150



Packaging

Packaging

Identify as per dwg & Stock Location: 277

0.00

Memo

0.00

Perp/27 C

# Work Order ID 56409

February 23, 2010 10:14:10 AM



Page 3

Item ID: D4050-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Strut

Start Date: 2/23/10 Start Qty: 1.00



Cust Item ID:

Required Date: 2/23/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/02/24

MF 10-2-24

# Picklist Print

February 23, 2010 10:14:09 AM

Page 1

Work Order ID: 56409

Parent Item: D4050-1

Parent Item Name: Strut

Comments: IPP RevA: new issue DD 10/01/05 verified by:EC IPP Rev:B as per dwg  
revB DD 10.02.18 verified by:EC

Start Date: 2/23/10

Required Date: 2/23/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

M304TR0.750W.065

Purchased

No

100

f

208.3762

1.4989



304 RD Tube .750 x .065W

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

MAT

208.3762

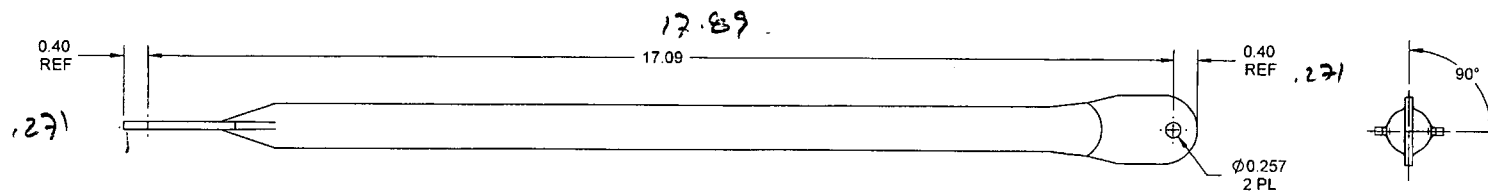
110113

108.3762

114002

100

1.4989 SB 10/02/24 0



8 D4050-1 STRUT

who 56409

RELEASED  
2010-02-16

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS TUBE  $\phi 0.750 \times 0.065$  WALL  
REF DART SPEC M304TR0.750W.065
  - 2) FINISH: POWDER COAT "WHITE" (4.3.5.2) PER DART QSI 005 4.3
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: 0.67 lbs
  - 8) PUNCH BOTH END PER SPEC CONTROL DRAWING D2638

B	REVISE WALL THICKNESS FOR -1/-3/-5/-8 0.065 WAS 0.049 (ZN A8-1, A8-2, A8-3, A8-4)	RF	10.02.02
A	NEW ISSUE	RF	10.01.28
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED	RF		
MFG. APPR.	RF		
APPROVED	RF		
DE APPR.	RF		
DATE	10.02.02		

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. <b>D4050</b>	REV. B SHEET 1 OF 4
TITLE <b>STRUT</b>	SCALE NTS

COPYRIGHT © 2010 BY DART AEROSPACE LTD  
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS  
NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT  
WRITTEN PERMISSION FROM DART AEROSPACE LTD